

Date: Tuesday, 31/03/2009 1:04:24 PM
 User: Julie Dawson

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	SPACER
Job Number	46738			
Estimate Number	10980			
P.O. Number	:		Part Number	D2808
This Issue	31/03/2009	S.O. No. :	Drawing Number	D2808 REV B
Prsht Rev.	NC		Project Number	N/A
First Issue	/ /	Type : MACHINED PARTS	Drawing Revision	B
Previous Run	42181		Material	:
Written By	:		Due Date	07/04/2009
Checked & Approved By	: <u>Jul 09 03:31</u>			
Comment	: Est Rev:D 02.03.07 Now turned in house NG Est Rev:E 07-12-18 RevB as per dwg ECN1048 DD verified by:EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0625	6061-T6 Round Bar .625"	
		Comment: Qty.: 0.0557 f(s)/Unit Total : 2.2260 f(s) 6061-T6 Round Bar .625" (M6061T6R0625) Batch: <u>M110250</u>	8" scrap. <i>On 09/04/08</i> 41
2.0	HARDINGE D25A. (This Batch Only)	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL	
		1-Turn as per Folio FA256 (Mesure D3387 Bracket .507" Dia for Proper press-fit)	
		2-Deburr	<i>On 09/04/08</i> 41
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>On 09/04/08</i> 41
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>On 09/04/09</i> 41
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	<i>On 09/04/09</i> 41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SPACER
Job Number: 46738		Part Number: D2808
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>jl</i> 
7.0	PACKAGING 1 	PACKAGING RESOURCE #1 <i>09-04-09</i> 
8.0	QC21 	FINAL INSPECTION/W/O RELEASE <i>9/4/09</i> 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION Identify and Stock: <i>49</i> Location: <i>49</i> <i>09-04-09</i>		
Comment: PACKAGING RESOURCE #1 Identify and Stock: <i>49</i> Location: <i>49</i> <i>09-04-09</i>		
Comment: FINAL INSPECTION/W/O RELEASE Job Completion  <i>mf 09-04-09</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	W6738
Description: Spacer	Part Number:	D2808
Inspection Dwg: D2808	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

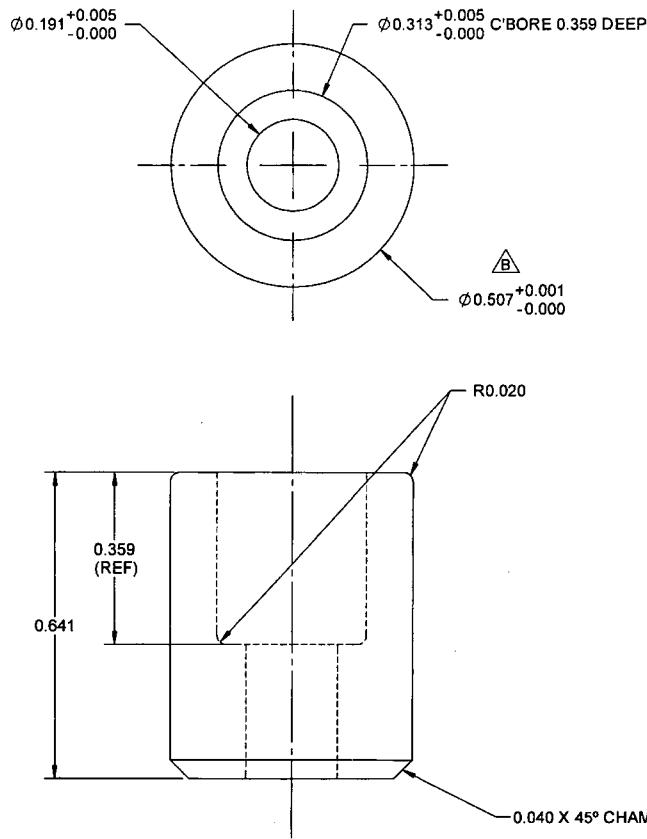
Measured by: My
Date: 02/04/08

Audited by:	<i>BB</i>
Date:	09/04/09

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	07.11.23	Ø0.507 dimension and tolerance revised	KJ/EC/DD	BS

8 7 6 5 4 3 2 1



D2808 SPACER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK IN PROGRESS
NO. 40138

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ENGINEERING

B	REMOVE POWDER COAT: Ø0.507 WAS Ø0.500	DC	07.10.12
A	NEW ISSUE	DS	00.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>A</i>		
DRAWN	<i>EC</i>		
CHECKED	<i>AS</i>		
MFG. APPR.	<i>NA</i>	DRAWING NO.	REV. B
APPROVED	<i>NA</i>	D2808	SHEET 1 OF 1
DE APPR.	<i>NA</i>	TITLE	SCALE
		SPACER	4:1
DATE	07.10.12	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

D

C

B

A

RELEASED
07.12.2012